

split

Work Order ID 149454 -2

149454 DRAB GREEN

Monday, July 25, 2016 1:15:16 PM

Item ID: D2803-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bracket Assembly
Start Date: 9/27/2016 Start Qty: ~~12.00~~ 11 *12* Cust Item ID:
Required Date: 9/30/2016 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: _____ Date: JUL 26 2016 Cooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Draw Nbr Revision Nbr								
	D2803 C								
100	Small Fab	0.00							
100	Small Fab	Memo							
Small Fab	Press D2805-1 and D2809 into arm as per Dwg D2803	0.10							
110	QC5- Inspect part completeness to step on W/O	0.00							
110	QC	Memo							
Quality Control		0.04							

12x _____ 16/09/20
DAS 36 9-1
12
38
SEP 21 2016

Work Order ID 149454

Monday, July 25, 2016 1:15:16 PM

149454

Page 3

Item ID: D2803-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket Assembly

Start Date: 9/27/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Run

Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00			DAS 30 9-89	(11)			NOV 08 2016
160 QC Quality Control	Memo	0.04							
170	Identify as per dwg & Stock Location: <u>6A</u>	0.00				11X			DAS 36 9-89 16/11/10
170 Packaging Packaging	Memo	0.02							
180	QC21- Final Inspection - Work Order Release	0.00							16/11/10 J
180 QC Quality Control	Memo	0.20							

DAS
21
9-89

NOV 09 2016

Picklist Print

Page 1

Monday, July 25, 2016 1:15:16 PM

Work Order ID: 149454

149454

Parent Item: D2803-041

D2803-041

Parent Item Name: Bracket Assembly

Start Date: 9/27/2016

Required Date: 9/30/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM IPP REV:G
16.06.23 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-1		Manufactured	No			100	Each	4.0000	1	12			
D2803-1									**			16/09/20	
Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST472				4				149378	(12x)
				146599				4					
D2805-1		Manufactured	No			100	Each	14.0000	1	12			
D2805-1									**			16/09/20	
Stop													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				14				149393	(9x)
				127509				4					
				146607				10		3			
D2809		Manufactured	No			100	Each	33.0000	1	12			
D2809									**			16/11/07	
Washer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				8					
				127638				4					
				130466				2					
				146514				2					
				ST011				25					
				138750				14					
				34035				11					

DAS
36
9-89DAS
36
9-DAS
36
9-89149434
(1x)

Picklist Print

Page 2

Monday, July 25, 2016 1:15:16 PM

Work Order ID: 149454

149454

Parent Item: D2803-041

D2803-041

Parent Item Name: Bracket Assembly

Start Date: 9/27/2016

Required Date: 9/30/2016

Start Qty: 12.00

Required Qty: 12.00

AN3C16A

Purchased

No

150

Each

89.0000

2

24

16/11/07 **DAS 36 989**

AN3C16A

BOLT

Location

Loc Qty

Loc Code

ST348

89

m131153

2

m131957

12

m134955

75

135704
22x

DAS 36 989

D3672-15

Manufactured

No

150

Each

231.0000

4

48

16/11/07

D3672-15

Phenolic Washer

Location

Loc Qty

Loc Code

ST050

231

148073

231

149430 (44x)

MS21043-3

Purchased

No

150

Each

920.0000

2

24

16/11/07

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

11

m130673

11

GA

237

m133990

237

OVER007

400

m135058

400

ST302

86

m134861

86

ST304

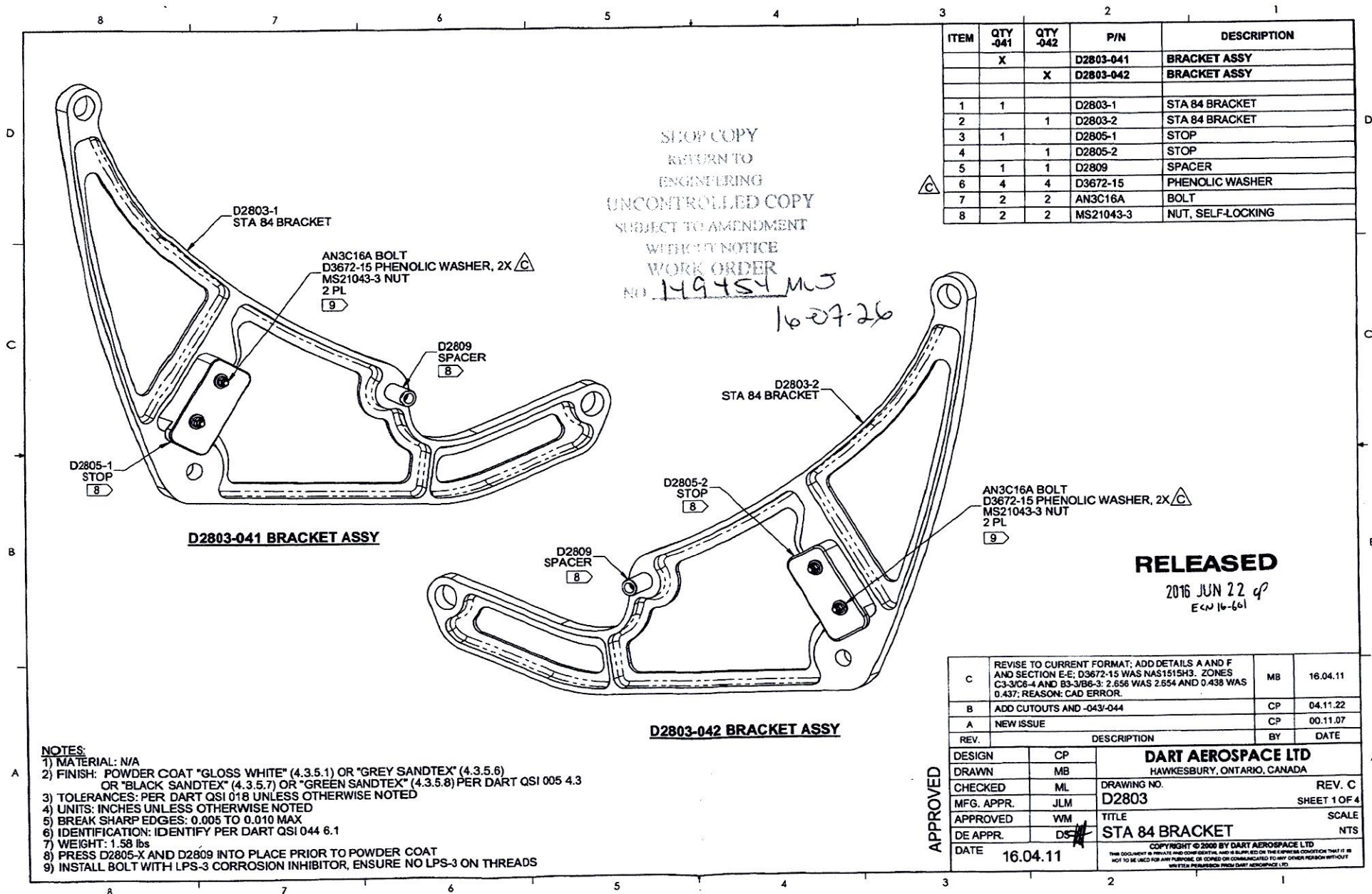
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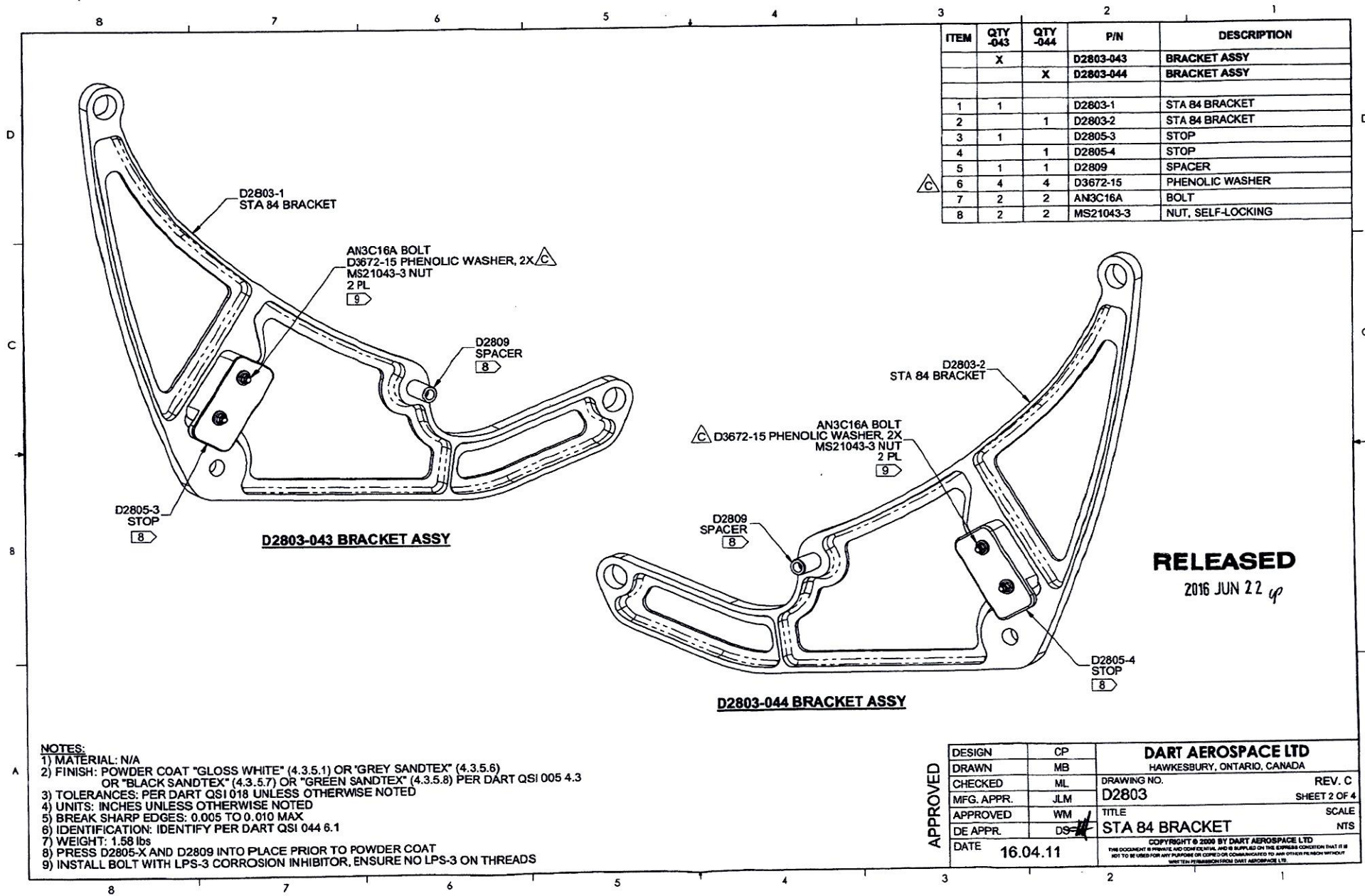
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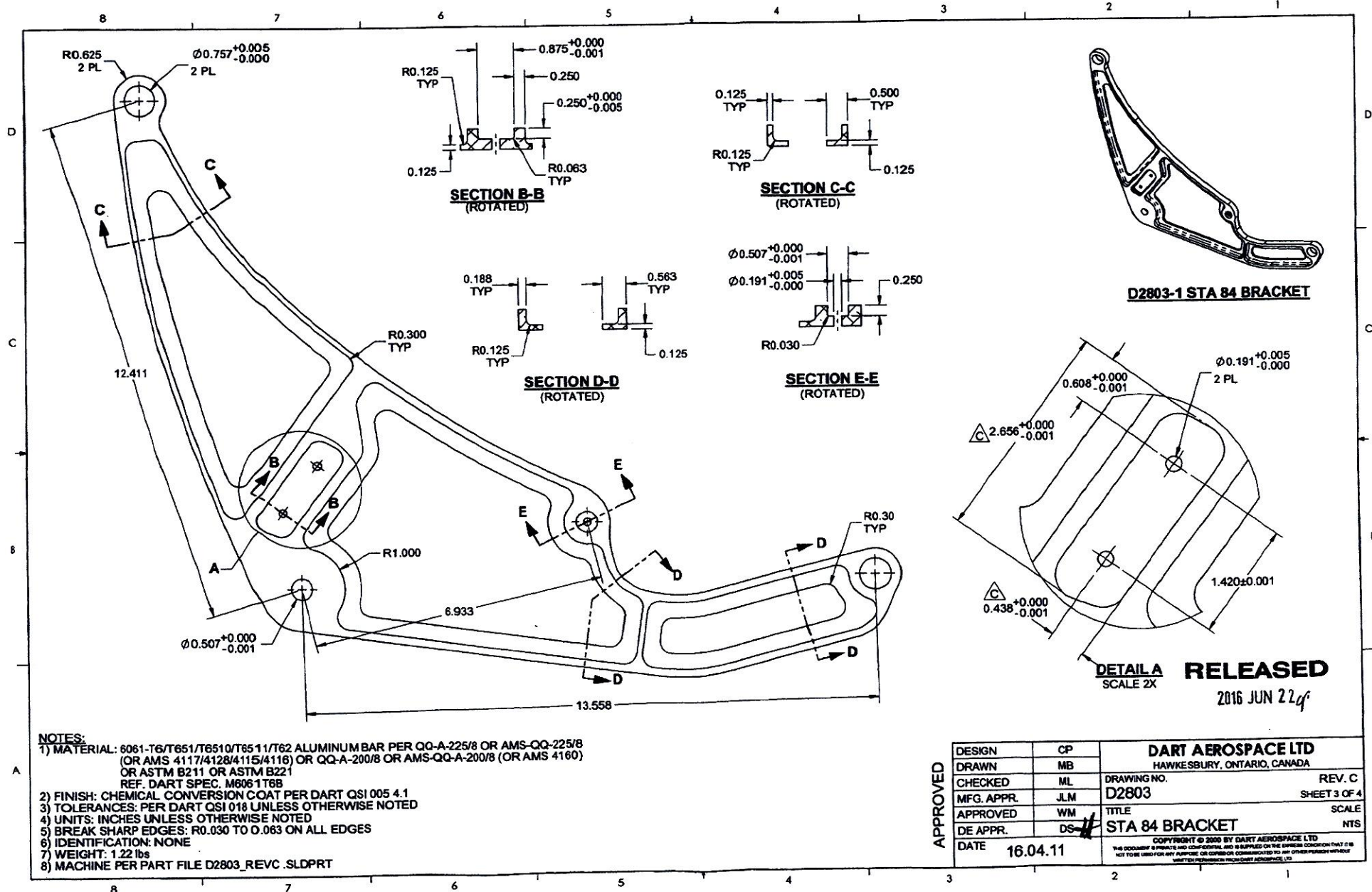
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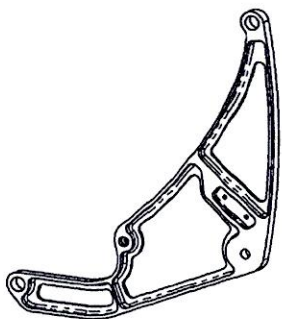
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DAS 36 989

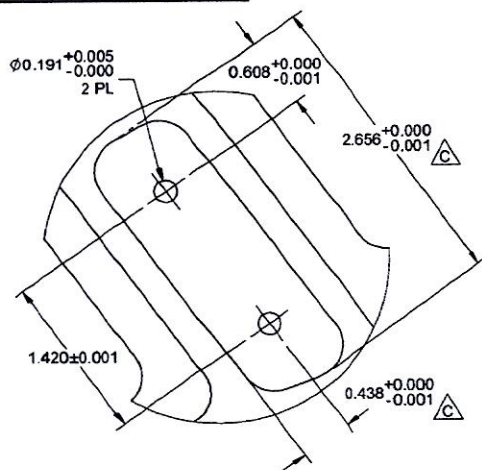




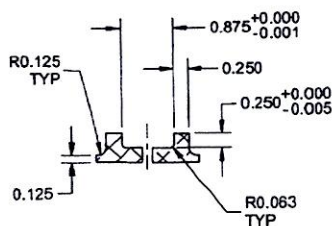




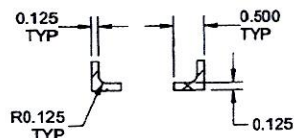
D2803-2 STA 84 BRACKET



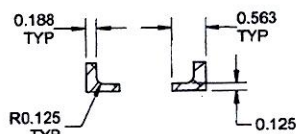
DETAIL F
SCALE 2X



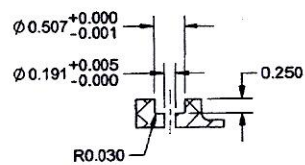
SECTION G-G
(ROTATED)



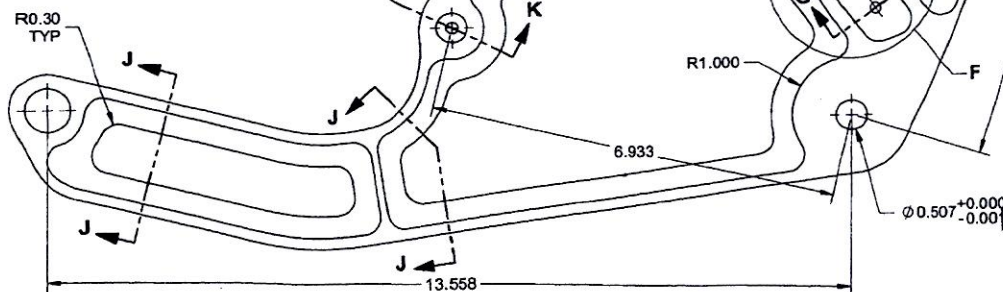
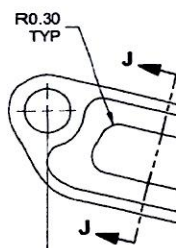
SECTION H-H
(ROTATED)



SECTION J-J
(ROTATED)



SECTION K-K
(ROTATED)



RELEASED
2016 JUN 22 *ap*

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: R0.030 TO 0.063 ON ALL EDGES
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.22 lbs
 - 8) MACHINE PER PART FILE D2803_REV.C .SLDPRT

APPROVED

DESIGN	CP
DRAWN	MB
CHECKED	ML
MFG. APPR.	JLM
APPROVED	WM
DE APPR.	DS
DATE	16.04.11

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2803	REV. C SHEET 4 OF 4
TITLE STA 84 BRACKET	SCALE NTS

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